



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification⁴ :
B29C 27/16, 63/34, B29D 23/10
F16L 58/10, 57/00

A1

(11) International Publication Number: WO 87/ 03840

(43) International Publication Date: 2 July 1987 (02.07.87)

(21) International Application Number: PCT/AU86/00362

(22) International Filing Date: 25 November 1986 (25.11.86)

(31) Priority Application Number: PH 3973

(32) Priority Date: 20 December 1985 (20.12.85)

(33) Priority Country: AU

(71)(72) Applicant and Inventor: SKOTT, Roy, Binall [AU/AU]; RMB 275, Darkes Forest, NSW 2508 (AU).

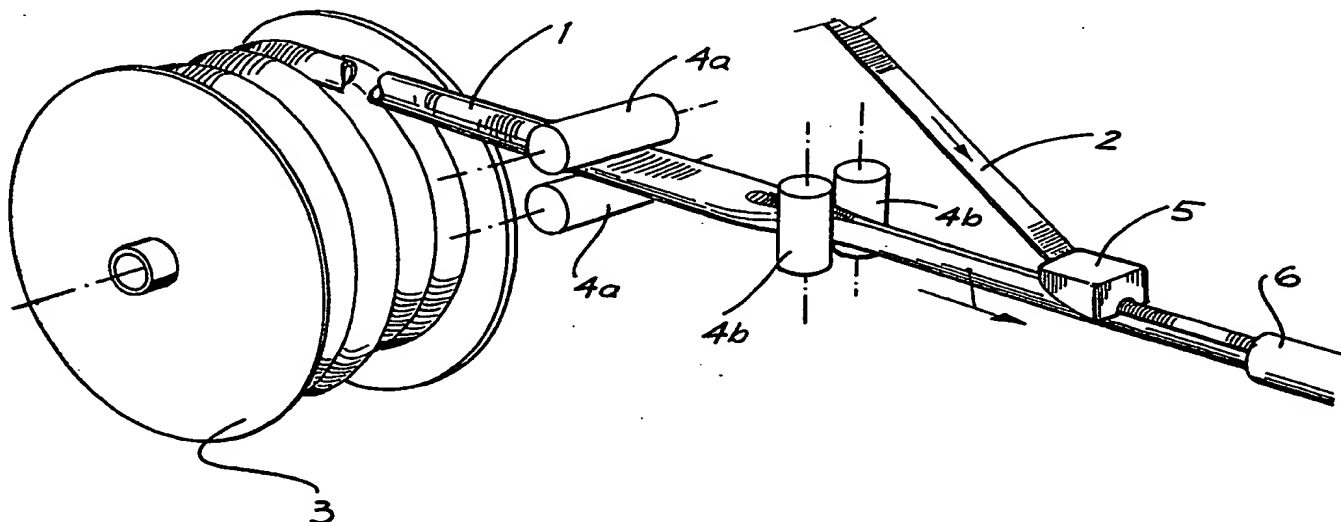
(74) Agent: F. B. RICE & CO.; 28A Montague Street, Balmain, NSW 2041 (AU).

(81) Designated States: AT (European patent), AU, BE (European patent), CH (European patent), DE (European patent), FR (European patent), GB (European patent), IT (European patent), JP, LU (European patent), NL (European patent), SE (European patent), US.

Published

With international search report.

(54) Title: METHOD AND MEANS FOR APPLYING FLEXIBLE LINERS TO PIPES



(57) Abstract

To line the internal surface of a pipe (6) such as a water, gas or drain pipe an inner plastics semi-rigid lining (1) is collapsed and retained in collapsed condition by a tearable strap (2). The collapsed state of the lining (1) being of a lesser maximum diameter than the underformed lining (1) so that it can readily fit within and along pipe (6). Severing of the strap (2) allows the lining (1) to resiliently expand to its original shape and closely fit the internal wall of the pipe (6).

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	FR	France	ML	Mali
AU	Australia	GA	Gabon	MR	Mauritania
BB	Barbados	GB	United Kingdom	MW	Malawi
BE	Belgium	HU	Hungary	NL	Netherlands
BG	Bulgaria	IT	Italy	NO	Norway
BJ	Benin	JP	Japan	RO	Romania
BR	Brazil	KP	Democratic People's Republic of Korea	SD	Sudan
CF	Central African Republic	KR	Republic of Korea	SE	Sweden
CG	Congo	LI	Liechtenstein	SN	Senegal
CH	Switzerland	LK	Sri Lanka	SU	Soviet Union
CM	Cameroon	LU	Luxembourg	TD	Chad
DE	Germany, Federal Republic of	MC	Monaco	TG	Togo
DK	Denmark	MG	Madagascar	US	United States of America
FI	Finland				

"METHOD AND MEANS FOR APPLYING FLEXIBLE LINERS TO PIPES

The present invention relates to the lining of pipes and more particularly to the lining of pipes with a plastics material. The invention provides an improved
5 in-situ method for pipe lining which has special utility for underground pipe systems.

Various methods have been proposed for lining pipes, however, the present invention overcomes certain impracticalities inherent in the prior art.

10 Common in the field has been a proposal to provide adhesive means to bond a plastics material liner to the inner surface of the pipe. In one particular method an adhesive is applied to the inner surface of the liner and the liner progressively axially everted within the pipe by
15 means of compressed air. In another method, the inner surface of the pipe is coated with a radiation curable adhesive and an extruded thermoplastic liner is introduced into the pipe, bonding being effected by means of a travelling radiation source.

20 The present invention provides means whereby a plastics material liner can be frictionally affixed to the inner surface of a pipe thereby overcoming the necessity of adhesive means. Additionally, frictional location of the liner overcomes the problems associated with thermally
25 activated methods allowing, in particular, non-metallic pipes to be lined.

The present invention provides a method of lining a pipe comprising the steps of providing a semi-rigid plastics tube having an external diameter corresponding to
30 the internal diameter of the pipe to be lined, forcibly collapsing the tube so as to form at least one longitudinally extending depression of the tube thereby decreasing the diameter of the tube, fixing a longitudinally extending tearable strap to or about the
35 pipe so as to maintain the collapsed configuration,



introducing the collapsed tube in its maintained collapsed configuration into the pipe for a desired distance along and within the pipe and releasing the strap in order to restore the tube to its original shape and bring it into
5 frictional contact with the internal wall of the pipe.

In another form the present invention provides a semi-rigid plastics tube maintained in a collapsed shape comprising at least one longitudinally extending depression of the tube and a tearable strap fixed to or
10 extending around the tube to maintain the maximum diameter of the collapsed tube at a lesser dimension than when the tube is uncollapsed.

In a preferred embodiment the strap may be composed of a laminated plastic film which is heat welded to the
15 tube. In another embodiment the strap is in the form of a plastics film wrapped all the way round the deformed or collapsed plastics tube so that the film is welded to itself to maintain the tube in its collapsed configuration. This arrangement is particularly
20 appropriate where the film cannot be readily adhered to the material of the tube. In such embodiments, release of the strap could be effected by cutting the strap or by pressurizing the tube.

In order that the invention may be better understood preferred forms thereof are hereinafter described by way of example with reference to the accompanying drawings in which:

Figs. 1 and 2 are cross-sectional views of an undefined length of extruded plastics tubing;

30 Fig. 3 is a cross-sectional view of the same piece of tubing together with a welded on plastics strap;

Figs. 4 and 5 are cross-sections of a second form of the invention;

Fig. 6 is a cross-sectional view similar to Fig. 3
35 with a plastics strap welded to itself; and

Fig. 7 is a schematic representation of a system according to the invention for the in situ collapsing of tubing and lining of pipes.

Fig. 1 shows a cross-section of a tube 1 which can be of an extruded plastics material such as low density polythene. As shown, the tube 1 has an outside diameter, D , so chosen as to correspond to the inside diameter of the pipe (not shown) to be lined. In Fig. 2 the same tube 1 is shown after it has been forcibly collapsed into a typical configuration having a major cross-sectional axis, d , such that $d < D$. This configuration is maintained by a tearable film 2 which is heat welded onto the tube as shown in Fig. 3. In this maintained collapsed configuration the tube 1 is introduced for a desired distance within and along the pipe to be lined. The film 2 is then cut or otherwise broken to enable the tube to return to its original shape. As the liner 1 returns to its original diameter, D , it frictionally engages the interior wall of the pipe.

Referring to Fig. 6, the only variation from the arrangement of Fig. 3 is that the film 2 wraps around tube 1 and is welded or adhered to itself rather than being affixed to tube 1. This arrangement is appropriate where the materials of the film 2 and tube 1 are not compatible for welding or the like. Where a tube 1 is to be employed in a high temperature or corrosive environment it may be necessary to use cross-linked polyethylene or polybutylene as the tube material such that welding of a film 2 may not be suitable.

The collapsed tubing can be conveniently spool fixed for delivery. Alternatively, on site apparatus can be provided to perform the collapsing and securing of the collapsed tube, such apparatus comprising roller means and heat welding means. In Fig. 7 a spool of uncollapsed tubing 1 is shown generally at 3. Roller means 4a, 4b

first substantially flatten and then arcuate the tubing, respectively, so as to produce a cross-sectional configuration as shown in Fig. 2. In close proximity to the roller means 4b is provided a welding station 5 which receives and fixes a tearable film 2 to the tube thereby maintaining the tube in a collapsed configuration as shown in Fig. 3. The tubing is then introduced within and along a pipe 6.

The embodiments described having regard to Figs. 1-3 and 6 is especially suited to the lining of small diameter pipes. A further embodiment is hereafter described having reference to Figs. 4 and 5 in which the invention has improved application to the lining of larger diameter pipes.

A tube of extruded plastics material such as low density polythene is provided as previously indicated in Fig. 1 and having a larger diameter to correspond to the inside diameter of larger pipes desired to be lined. The tube is substantially flattened as shown in Fig. 4 and subsequently arcuated as shown in Fig. 5. Description of this embodiment is in other respects as discussed above. This second embodiment has improved practical value since the flattened liner shown in Fig. 4 can be spool fixed for delivery thereby obviating the necessity of roller means 4a. Clearly, further steps can be taken to reduce the on-site apparatus shown in Fig. 7 and thereby increase the versatility of applications of the invention.

CLAIMS:-

1. A method of lining a pipe comprising the steps of providing a semi-rigid plastics tube having an external diameter corresponding to the internal diameter of the pipe to be lined, forcibly collapsing the tube so as to form at least one longitudinally extending depression of the tube thereby decreasing the diameter of the tube, fixing a longitudinally extending tearable strap to or about the pipe so as to maintain the collapsed configuration, introducing the collapsed tube in its maintained collapsed configuration into the pipe for a desired distance along and within the pipe and releasing the strap in order to restore the tube to its original shape and bring it into frictional contact with the internal wall of the pipe.
2. A method as claimed in claim 1, wherein the tearable strap is welded to the tube.
3. A method as claimed in claim 1, wherein the tearable strap surrounds the collapsed tube and is affixed to itself.
4. A method as claimed in any one of the preceding claims, wherein the tube is collapsed and maintained in its collapsed configuration at a location remote from the pipe then transported to be introduced into the pipe.
5. A method as claimed in any one of claims 1 to 3, wherein the tube is collapsed and maintained in its collapsed configuration at a location adjacent the pipe to be lined.
6. A method as claimed in any one of the preceding claims, wherein the tube is produced from any one of polyethylene and its copolymers, cross-linked polythene and polybutylene.
7. A semi-rigid plastics tube maintained in a collapsed shape comprising at least one longitudinally extending depression of the tube and a tearable strap fixed to or

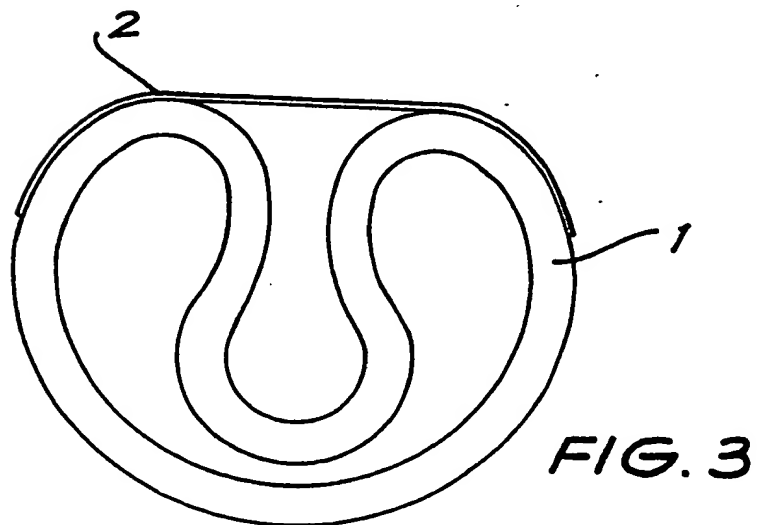
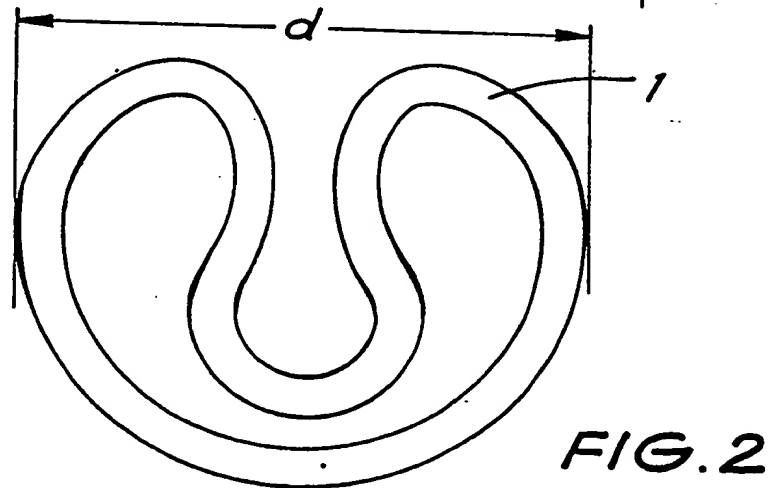
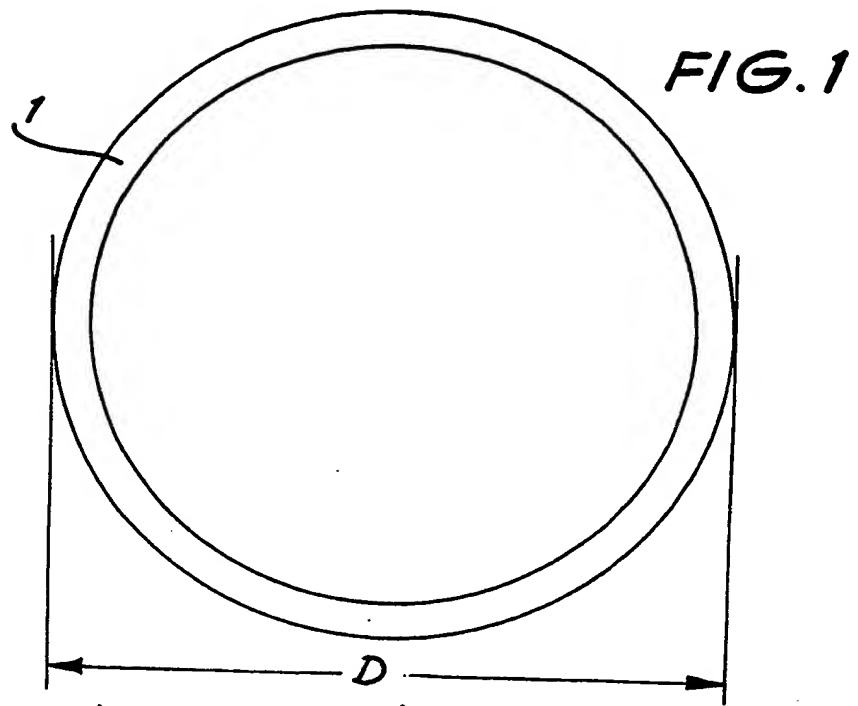
extending around the tube to maintain the maximum diameter of the collapsed tube at a lesser dimension than when the tube is uncollapsed.

8. A plastics tube as claimed in claim 7, wherein the tube is produced from any one of polyethylene and its copolymers, cross-linked polythene and polybutylene.

9. A method of lining a pipe substantially as hereinbefore described with reference to the accompanying drawings.

10. A semi-rigid plastics tube maintained in a collapsed state substantially as hereinbefore described with reference to Figs. 1-3, 4 and 5 or Fig. 6 of the accompanying drawings.

1/3



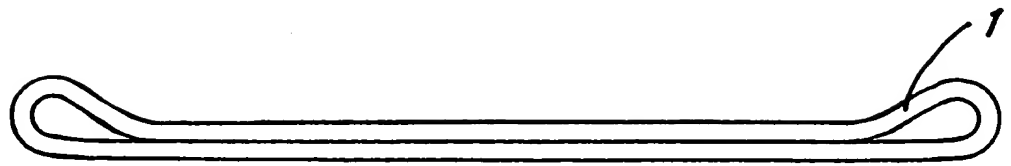


FIG. 3

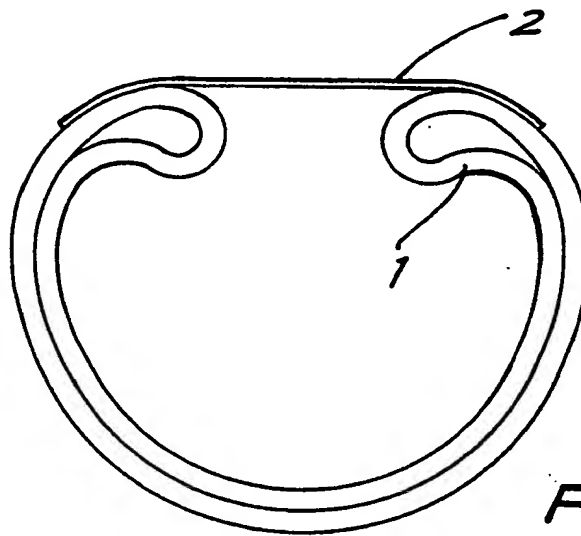


FIG. 4

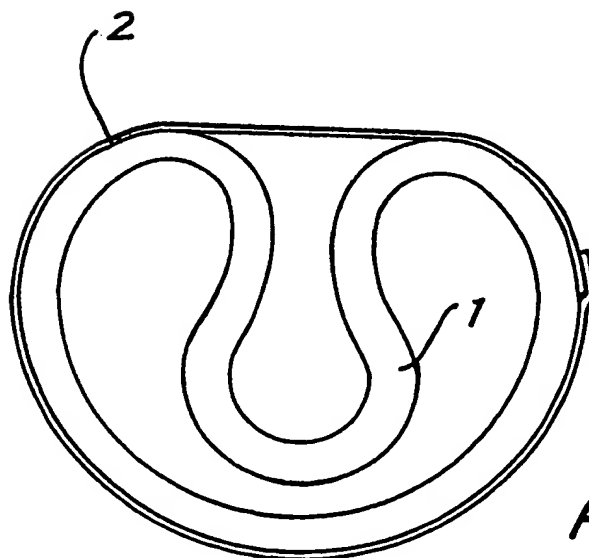
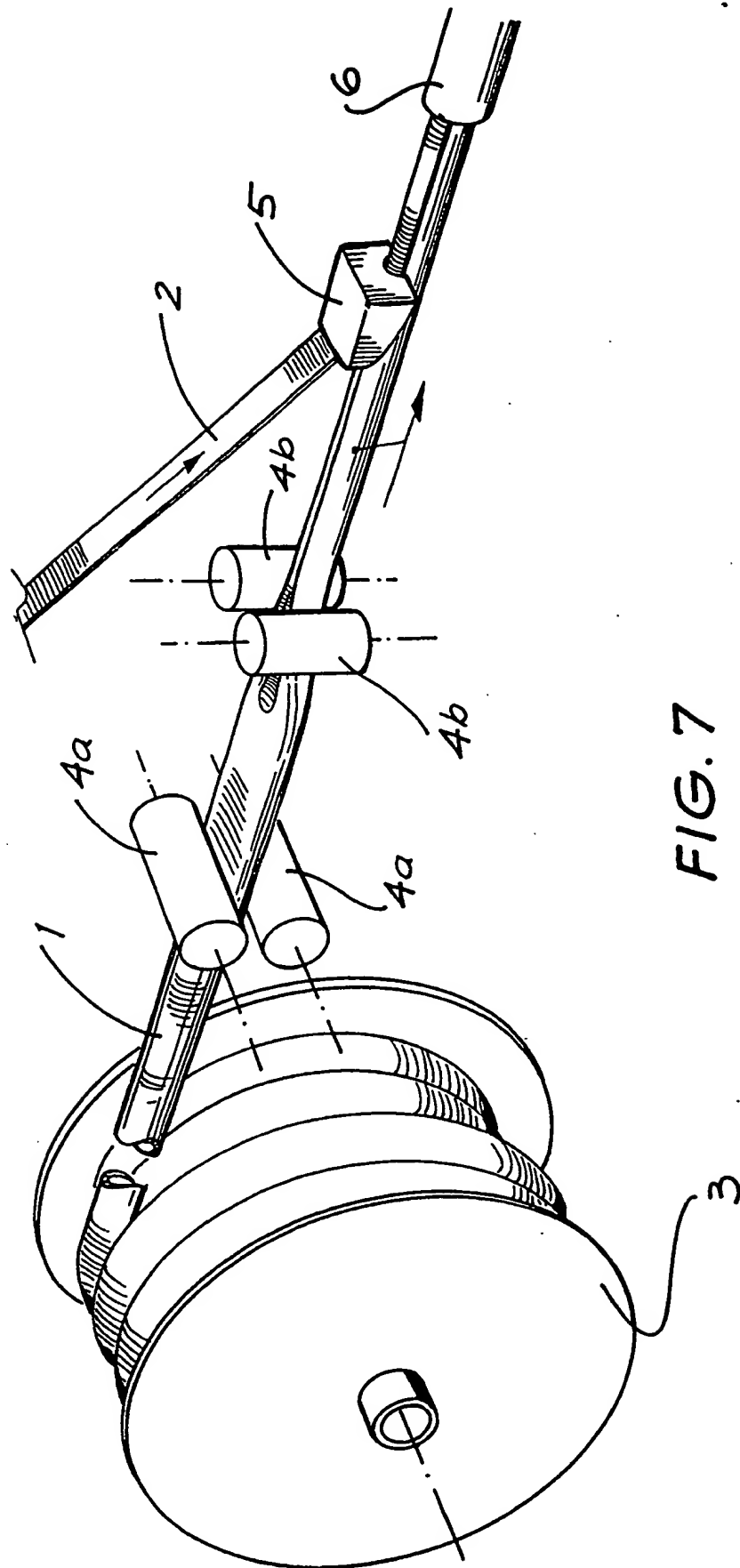


FIG. 6



INTERNATIONAL SEARCH REPORT

International Application No PCT/AU 86/00362

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) * According to International Patent Classification (IPC) or to both National Classification and IPC <div style="text-align: center; font-family: monospace; font-size: 1.2em;">Int. Cl.⁴ B29C 27/16, 63/34, B29D 23/10, F16L 58/10, 57/00</div>																	
II. FIELDS SEARCHED <div style="text-align: center; font-size: 0.8em;">Minimum Documentation Searched ?</div> <table style="width: 100%; border: none;"> <tr> <td style="width: 30%; border: none; vertical-align: top;"> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="text-align: left; padding: 2px;">Classification System</th> <th style="text-align: left; padding: 2px;">Classification Symbols</th> </tr> <tr> <td style="padding: 5px; text-align: center;">IPC</td> <td style="padding: 5px;">B29C 27/16 F16L 58/10, 57/00</td> </tr> </table> </td> <td style="border: none;"></td> </tr> </table> <div style="text-align: center; font-size: 0.8em; margin-top: 5px;">Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched *</div> <div style="padding: 10px 0;"> AU : IPC as above </div>			<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="text-align: left; padding: 2px;">Classification System</th> <th style="text-align: left; padding: 2px;">Classification Symbols</th> </tr> <tr> <td style="padding: 5px; text-align: center;">IPC</td> <td style="padding: 5px;">B29C 27/16 F16L 58/10, 57/00</td> </tr> </table>	Classification System	Classification Symbols	IPC	B29C 27/16 F16L 58/10, 57/00										
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="text-align: left; padding: 2px;">Classification System</th> <th style="text-align: left; padding: 2px;">Classification Symbols</th> </tr> <tr> <td style="padding: 5px; text-align: center;">IPC</td> <td style="padding: 5px;">B29C 27/16 F16L 58/10, 57/00</td> </tr> </table>	Classification System	Classification Symbols	IPC	B29C 27/16 F16L 58/10, 57/00													
Classification System	Classification Symbols																
IPC	B29C 27/16 F16L 58/10, 57/00																
III. DOCUMENTS CONSIDERED TO BE RELEVANT * <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="width: 10%; text-align: left; padding: 2px;">Category *</th> <th style="width: 70%; text-align: left; padding: 2px;">Citation of Document, ¹¹ with indication, where appropriate, of the relevant passages ¹²</th> <th style="width: 20%; text-align: left; padding: 2px;">Relevant to Claim No. ¹³</th> </tr> <tr> <td style="text-align: center; vertical-align: top; padding: 5px;">X</td> <td style="padding: 5px;">AU,A, 16542/83 (TRIO ENGINEERING LIMITED) 5 January 1983 (05.01.83)</td> <td style="text-align: center; vertical-align: top; padding: 5px;">1-10</td> </tr> <tr> <td style="text-align: center; vertical-align: top; padding: 5px;">X</td> <td style="padding: 5px;">AU,B, 38373/78 (TRIO ENGINEERING LIMITED) 31 January 1980 (31.01.80)</td> <td style="text-align: center; vertical-align: top; padding: 5px;">1-10</td> </tr> <tr> <td style="text-align: center; vertical-align: top; padding: 5px;">X</td> <td style="padding: 5px;">FR, 2199090 (STABILATOR AB) 26 September 1974 (26.09.74)</td> <td style="text-align: center; vertical-align: top; padding: 5px;">1-10</td> </tr> <tr> <td style="text-align: center; vertical-align: top; padding: 5px;">A</td> <td style="padding: 5px;">AU,A, 36219/84 (KAWASAKI STEEL CORPORATION) 13 June 1985 (13.06.85)</td> <td></td> </tr> </table>			Category *	Citation of Document, ¹¹ with indication, where appropriate, of the relevant passages ¹²	Relevant to Claim No. ¹³	X	AU,A, 16542/83 (TRIO ENGINEERING LIMITED) 5 January 1983 (05.01.83)	1-10	X	AU,B, 38373/78 (TRIO ENGINEERING LIMITED) 31 January 1980 (31.01.80)	1-10	X	FR, 2199090 (STABILATOR AB) 26 September 1974 (26.09.74)	1-10	A	AU,A, 36219/84 (KAWASAKI STEEL CORPORATION) 13 June 1985 (13.06.85)	
Category *	Citation of Document, ¹¹ with indication, where appropriate, of the relevant passages ¹²	Relevant to Claim No. ¹³															
X	AU,A, 16542/83 (TRIO ENGINEERING LIMITED) 5 January 1983 (05.01.83)	1-10															
X	AU,B, 38373/78 (TRIO ENGINEERING LIMITED) 31 January 1980 (31.01.80)	1-10															
X	FR, 2199090 (STABILATOR AB) 26 September 1974 (26.09.74)	1-10															
A	AU,A, 36219/84 (KAWASAKI STEEL CORPORATION) 13 June 1985 (13.06.85)																
<div style="display: flex; justify-content: space-between;"> <div style="width: 48%;"> <p>* Special categories of cited documents: ¹⁰</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </div> <div style="width: 48%;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"A" document member of the same patent family</p> </div> </div>																	
IV. CERTIFICATION <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none; vertical-align: top;"> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 5px;"> Date of the Actual Completion of the International Search <div style="text-align: center; font-family: monospace; font-size: 1.1em;">16 February 1987 (16.02.87)</div> </td> </tr> <tr> <td style="padding: 5px;"> International Searching Authority <div style="text-align: center; font-weight: bold;">Australian Patent Office</div> </td> </tr> </table> </td> <td style="width: 50%; border: none; vertical-align: top;"> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 5px;"> Date of Mailing of this International Search Report <div style="text-align: center; font-family: monospace; font-size: 1.2em;">3-3-81 - 3-MARCH 1987</div> </td> </tr> <tr> <td style="padding: 5px;"> Signature of Authorized Officer <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="font-family: cursive; font-size: 1.2em;">J.L. Werner</div> <div style="text-align: right; font-weight: bold;">J.L. WERNER</div> </div> </td> </tr> </table> </td> </tr> </table>			<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 5px;"> Date of the Actual Completion of the International Search <div style="text-align: center; font-family: monospace; font-size: 1.1em;">16 February 1987 (16.02.87)</div> </td> </tr> <tr> <td style="padding: 5px;"> International Searching Authority <div style="text-align: center; font-weight: bold;">Australian Patent Office</div> </td> </tr> </table>	Date of the Actual Completion of the International Search <div style="text-align: center; font-family: monospace; font-size: 1.1em;">16 February 1987 (16.02.87)</div>	International Searching Authority <div style="text-align: center; font-weight: bold;">Australian Patent Office</div>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 5px;"> Date of Mailing of this International Search Report <div style="text-align: center; font-family: monospace; font-size: 1.2em;">3-3-81 - 3-MARCH 1987</div> </td> </tr> <tr> <td style="padding: 5px;"> Signature of Authorized Officer <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="font-family: cursive; font-size: 1.2em;">J.L. Werner</div> <div style="text-align: right; font-weight: bold;">J.L. WERNER</div> </div> </td> </tr> </table>	Date of Mailing of this International Search Report <div style="text-align: center; font-family: monospace; font-size: 1.2em;">3-3-81 - 3-MARCH 1987</div>	Signature of Authorized Officer <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="font-family: cursive; font-size: 1.2em;">J.L. Werner</div> <div style="text-align: right; font-weight: bold;">J.L. WERNER</div> </div>									
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 5px;"> Date of the Actual Completion of the International Search <div style="text-align: center; font-family: monospace; font-size: 1.1em;">16 February 1987 (16.02.87)</div> </td> </tr> <tr> <td style="padding: 5px;"> International Searching Authority <div style="text-align: center; font-weight: bold;">Australian Patent Office</div> </td> </tr> </table>	Date of the Actual Completion of the International Search <div style="text-align: center; font-family: monospace; font-size: 1.1em;">16 February 1987 (16.02.87)</div>	International Searching Authority <div style="text-align: center; font-weight: bold;">Australian Patent Office</div>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 5px;"> Date of Mailing of this International Search Report <div style="text-align: center; font-family: monospace; font-size: 1.2em;">3-3-81 - 3-MARCH 1987</div> </td> </tr> <tr> <td style="padding: 5px;"> Signature of Authorized Officer <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="font-family: cursive; font-size: 1.2em;">J.L. Werner</div> <div style="text-align: right; font-weight: bold;">J.L. WERNER</div> </div> </td> </tr> </table>	Date of Mailing of this International Search Report <div style="text-align: center; font-family: monospace; font-size: 1.2em;">3-3-81 - 3-MARCH 1987</div>	Signature of Authorized Officer <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="font-family: cursive; font-size: 1.2em;">J.L. Werner</div> <div style="text-align: right; font-weight: bold;">J.L. WERNER</div> </div>												
Date of the Actual Completion of the International Search <div style="text-align: center; font-family: monospace; font-size: 1.1em;">16 February 1987 (16.02.87)</div>																	
International Searching Authority <div style="text-align: center; font-weight: bold;">Australian Patent Office</div>																	
Date of Mailing of this International Search Report <div style="text-align: center; font-family: monospace; font-size: 1.2em;">3-3-81 - 3-MARCH 1987</div>																	
Signature of Authorized Officer <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="font-family: cursive; font-size: 1.2em;">J.L. Werner</div> <div style="text-align: right; font-weight: bold;">J.L. WERNER</div> </div>																	

ANNEX TO THE INTERNATIONAL SEARCH REPORT ON
INTERNATIONAL APPLICATION NO. PCT/AU 86/00362

This Annex lists the known "A" publication level patent family members relating to the patent documents cited in the above-mentioned international search report. The Australian Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

Patent Document
Cited in Search
Report

Patent Family Members

AU 16542/83	DK 3051/83	EP 98547	ES 523780
	JP 59140989	NO 832378	

AU 38373/78	CA 1115917	DK 3324/78	EP 576
	ES 472 063	GB 2003576	JP 55133923
	NO 782548	US 4207130	DE 2345091

FR 2199090	GB 1437273	NL 7312202	US 3894328
------------	------------	------------	------------

AU 36219/84	BR 8406218	JP 60121380	
-------------	------------	-------------	--

END OF ANNEX